

Work Order ID 156244

Friday, January 27, 2017 12:49:53 PM

156244

Page 1

Item ID: D350-588-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Door Fwd Hinge Modification
 Start Date: 1/25/2017 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 2/2/2017 Req'd Qty: 5.00 ***5*** Customer:
 Reference: 17-3-2017
 31-3-2017

Approvals: Process Plan: **DAS 21 9-89** Date: **JAN 31 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-588	D								
DSI9690	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-588-011 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

MAR 30 2017

DAS 6 9-89

DAS 21 9-89 CB 1703-31

DAS 28 9-89 5 APR 04 2017

DAS 6 9-89 5 APR 03 2017 **DAS 27 9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Work Order ID 156244

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156244

Page 2

Item ID: D350-588-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017 Start Qty: 5.00

5

Cust Item ID:

Required Date: 2/2/2017 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.02

Quality Control

5

DAS
28
9-89

APR 04 2017

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-588-011
Location :FG022

5

DAS
28
9-89

APR 04 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.08

Quality Control

DAS
21
9-89

APR 05 2017

DAS
21
9-89

APR 05 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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156244

D350-588-011

Required Date: 2/2/2017

Required Qty: 5.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM IPP REV:G
14.04.28 AS PER DSI9690 DD VEF:JLM

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

D2143 Manufactured No

120 Each

29.0000

1 5

APR 03 2017

D2143

Hinge Bracket

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST002

29

141033

7

150285

12

152427

10

D2144 Manufactured No

120 Each

28.0000

1 5

APR 03 2017

D2144

Hinge Doubler

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST002

28

141066

8

150971

20

D2150 Manufactured No

120 Each

37.0000

2 10

APR 03 2017

D2150

Packer Doubler, Hinge

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST002

17

141069

17

ST003

20

152300

20

D2151 Manufactured No

120 Each

42.0000

2 10

APR 03 2017

D2151

Packer Doubler

**

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST002

42

141044

22

152281

20

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Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Picklist Print

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Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

D2153 Manufactured No

120 Each

32.0000

1 5

D2153

Door Prop

DAS
28
9-89

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST362

32

152433

32

D2154 Manufactured No

120 Each

30.0000

1 5

D2154

Bracket, Stud

DAS
28
9-89

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST003

30

118894

5

145373

14

152222

11

D2237 Manufactured No

120 Each

67.0000

2 10

D2237

Striker Plate

DAS
28
9-89

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST004

67

150093

17

152168

20

153454

10

154292

20

D2461 Manufactured No

120 f

345.0772

7.25 38.15789

D2461

Neoprene 'D' Seal (\$Per Foot)

DAS
28
-89

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST407

345.0772268

144533

345.077227

152518x2
158351x3

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

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Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

D2463 Manufactured No 120 f

478.2506 ~~7.25~~ 38.15789

D2463 ~~0880~~

1/2" Seal (\$ per foot)

**

APR 03 2017

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST409

478.2506391

140013

0.00063908

148875

478.25

D2583 Manufactured No 120 Each

49.0000 2 10

D2583

Latch Bracket

**

APR 03 2017

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST481

49

152314

24

154221

25

D2585 Manufactured No 120 Each

62.0000 2 10

D2585

Latch Clamp

**

APR 03 2017

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST008

25

149785

2

150470

8

154228

15

ST012a

37

152338

15

152476

22

DAS 28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐						Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

D2586 Manufactured No 120 Each 87.0000 2 10

D2586

Door Latch

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
FG	12	
139228	8	
152211	4	
ST481	15	
152211	15	
ST486a	50	
153582	25	
154875	25	
ST488a	10	
150060	10	

DAS
28
9-89

D2587 Manufactured No 120 Each 29.0000 1 5

D2587

Door Plug

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
ST008	29	
150316	9	
152274	10	
154216	10	

DAS
28
9-89

D2589 Manufactured Yes 120 Each 58.0000 1 5

D2589

Keys, Key Chain

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
ST008	58	
132942	58	

DAS
28
9-89

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Friday, January 27, 2017 12:49:51 PM

Page 6

Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

D2690-17

Manufactured No

120

Each

24.0000

1

5

D2690-17

Cable

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST009

1

140042

1

ST012a

23

142810

9

150107

4

152174

10

D2857-1

Manufactured No

120

Each

40.0000

1

5

D2857-1

Hinge Bracket

**

APR 03 2017

DA
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

144748

1

150331

3

91914

1

ST012a

35

150331

11

152448

24

D2857-2

Manufactured No

120

Each

34.0000

1

5

D2857-2

Hinge Bracket

**

APR 03 2017

DA
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

3

140972

2

78904

1

ST012

7

144616

7

ST012a

24

152184

24

Friday, January 27, 2017 12:49:52 PM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
☐ OTHER : _____							

Picklist Print

Friday, January 27, 2017 12:49:52 PM

Page 7

Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

D2858-1

Manufactured No

120

Each

28.0000

1

5

D2858-1

Hinge Bracket

**

APR 03 2017

DAS
6
89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST012

16

140966

1

150112

15

ST012a

12

152740

12

D2858-2

Manufactured No

120

Each

36.0000

1

5

D2858-2

Hinge Bracket

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

2

77020

2

ST012

10

141043

3

145856

7

ST012a

24

152277

24

D5080-041

Manufactured No

120

Each

9.0000

2

10

D5080-041

Striker Plate Assembly

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST148

9

143432

9

β152250

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Friday, January 27, 2017 12:49:52 PM

Page 8

Work Order ID: 156244

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

156244

D350-588-011

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

FG-778150-550-ROL

Purchased

No

120

sf

1,107.166

1

6.666667

***FG-778150-550-ROL ***

7781 9 oz Glass 50" x 125 yd

DAS
28
9-89

Location

Loc Qty

Loc Code

CA2

1107.166712

M127701

4.00004485

M134550

1103.16667

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

MS20426AD3-4

Purchased

No

120

Each

8,848.000

12

60

MS20426AD3-4

RIVET

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

4885

m136444

4885

ST312

3963

m134294

3963

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

MS20470AD4-5

Purchased

No

120

Each

883.0000

18

90

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

37

m133860

37

ST310

846

m134654

846

**

APR 03 2017

DAS
6
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Picklist Print

Friday, January 27, 2017 12:49:52 PM

Page 9

Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

120

Each

844.0000

18

90

MS21042L08

Nut

★★

APR 03 2017

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

503

m135274

18

m135978

485

ST303

341

m136301

174

m136537

7

m136643

160

136975

MS21042L3

Purchased

No

120

Each

1,988.000

4

20

MS21042L3

Nut

★★

APR 03 2017

DAS
27
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

158

m134360

108

m135135

50

OVER007

1000

M136554

500

M136665

500

ST303

730

M136044

11

M136192

219

M136406

500

137073

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Friday, January 27, 2017 12:49:52 PM

Work Order ID: 156244

156244

Parent Item: D350-588-011

D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 1/25/2017

Required Date: 2/2/2017

Start Qty: 5.00

Required Qty: 5.00

MS27039-08-11

Purchased

No

120

Each

235.0000

2

10

MS27039-08-11

SCREW

DAS
28
9-89

Location

Loc Qty

Loc Code

ST278

235

m135864

235

MS27039-1-15

Purchased

No

120

Each

220.0000

2

10

MS27039-1-15

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

1

m127916

1

over006

100

m136554

100

ST280

119

m134852

19

m136406

100

NAS1149D0363J

Purchased

No

120

Each

821.0000

4

20

NAS1149D0363.I

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

233

m134055

233

ST263

588

m136318

588

NAS1149DN832J

Purchased

No

120

Each

1,548.000

24

120

NAS1149DN832.I

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

1548

M135297

1548

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	☐ OTHER : _____			

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156244 MGS
1701-31

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-588 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-588 REV. D
REF TCCA STC SH92-41
FAA STC SH1012NE

1.0 PURPOSE:

The purpose of this Dart Service Instruction is to provide customers with directions to install a modified striker plate that will provide more clearance around environmental/conductive seals that protrude inboard of the door frame structure on AS355 N/NP models.

2.0 PROCEDURE:

- 1) Install D350-588-011/-041 per Section 3.1/3.2 of D350-588 as applicable, except do not install D2237 striker plates per item 10 of Section 3.1.
- 2) Remove the aft environmental/conductive seal to gain access to the door structure.
- 3) Using a fine point marker, mark location of both striker plates based on door latch location.
- 4) If D2237 Striker Plates are currently installed, remove both striker plates by drilling out rivets.
- 5) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285$ " (#30) holes into the aft bulkhead.
- 6) Drill out both rivets on the aircraft skin adjacent to the striker plate assemblies.
- 7) Align D5080-041 striker plate assembly in the previously marked location and transfer drill the $\varnothing 0.1285$ " (#30) holes from the aircraft skin to the striker plate assembly.
- 8) Deburr holes and remove all sharp edges.
- 9) Touch up all holes in aluminum with chemical conversion coating in accordance with MIL-DTL-5541.
- 10) Apply 0.125" thick layer of PR-1775B ProSeal to the face of D5080-041 per Figure 1.
- 11) Install D5080-041 striker plate assemblies to the aft bulkhead using CR3213-4 rivets of a suitable length, and to the skin of the aircraft using PR-1775B coated CR3213-4 rivets of a suitable length.
- 12) Reinstall environmental/conductive seal using manufacturers recommended procedure.
- 13) Install gas strut or cable assembly per D350-588 Figure 5.
- 14) Adjust both latch mechanisms to ensure adequate compression of door seal and that door skin is flush.
- 15) Check door for proper operation by opening and closing the door, and ensure latches fully lock.

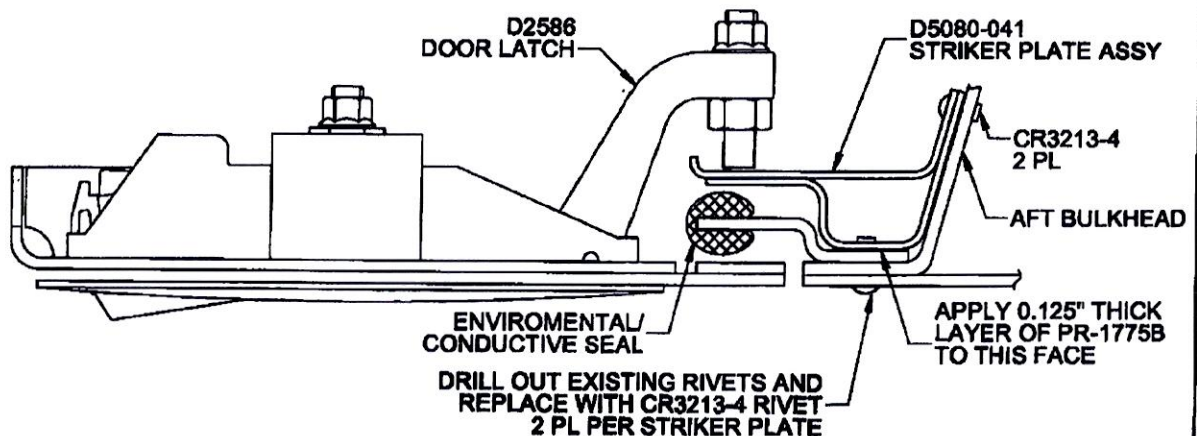


Figure 1 Striker Plate

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

A	NEW ISSUE	ML	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. 0 are amended as follows.

IS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D5080-041	STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY)
2	2	D2237	STRIKER PLATE

WAS:

588 -041	588 -011	PART NUMBER	DESCRIPTION
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MOD
2	2	D2237	STRIKER PLATE

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9690-011	STRIKER PLATE MODIFICATION KIT
2	D5080-041	STRIKER PLATE ASSEMBLY

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:

Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9690	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STRIKER PLATE MOD	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.3 **WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 **PARTS LISTS**

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)